Work Order ID 81468

March-14-12 11:45:20 AM

81468

Item ID: D2673-34 | Accept *N900040100* | Setup Start *NS1* Stop *NS2*

Revision ID:

Item Name: End Plate

Start Date: 14/03/2012 **Start Qty:** 30.00 *30*

Required Date: 28/03/2012 **Req'd Qty:** 30.00 *30*

Cust Item ID:

Customer:

Reference:

Run Start *NR1* Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12/03/14 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2673	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Handwritten entries
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D2673 Dwg Rev: B Prog Rev: B 2-Deburr if necessary	0.00 0.00	W 12 . 03 . 14 (30)
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	W 12 . 03 . 15 (30)
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	S 12/03/15 ; cuts (30)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 81468

March-14-12 11:45:20 AM

81468

Item ID: D2673-34

Revision ID:

Item Name: End Plate

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 14/03/2012 **Start Qty:** 30.00 *30*

Required Date: 28/03/2012 **Req'd Qty:** 30.00 *30*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: IMA **Memo**	0.00 0.00	12·03·26			30	Ø		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				MCJ 12/03/26			

12·03·26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-14-12 11:45:24 AM

Work Order ID: 81468 *81468*

Parent Item: D2673-34 *D2673-34*

Parent Item Name: End Plate

Start Date: 14/03/2012 **Required Date:** 28/03/2012

Start Qty: 30.00 **Required Qty:** 30.00

Comments: IPP C02.01.14Removed deburr and inspect level 5NG/EC
IPP Rev:D Now 6061-T6 06-06-23 JLM
IPP Rev:C Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 *M6061T6S.080* 6061-T6 .080 Sheet		Purchased	No			100	sf	157.7000	0.052 **	1.642105	W	12·03·14	

Location	Loc Qty	Loc Code
MAT021	157.7	
117285	3.8	
119766	40	
120349	113.9	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	81468
Description: End Plate	**Part Number:**	**D2673-34**
Inspection Dwg: D2673 **Rev:** B		**Page 1 of 1**

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article** [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.300	+/-0.010	3.294	✓		vern	HB-02
2.247	+/-0.010	2.241	✓		vern	
R0.250	+/-0.010	R 0.250	✓		RG	

Measured by:	[signature]
Date:	12 03 15

Audited by:	[signature]
Date:	12/3/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	
B	04.06.15	Remove 1.162, 2.188 & 0.556 dimensions	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	CB	
CHECKED PH	APPROVED [signature]	DRAWING NO. D2673 — REV. B — SHEET 1 OF 1
DATE 06.05.29		TITLE END PLATE — SCALE 1:1

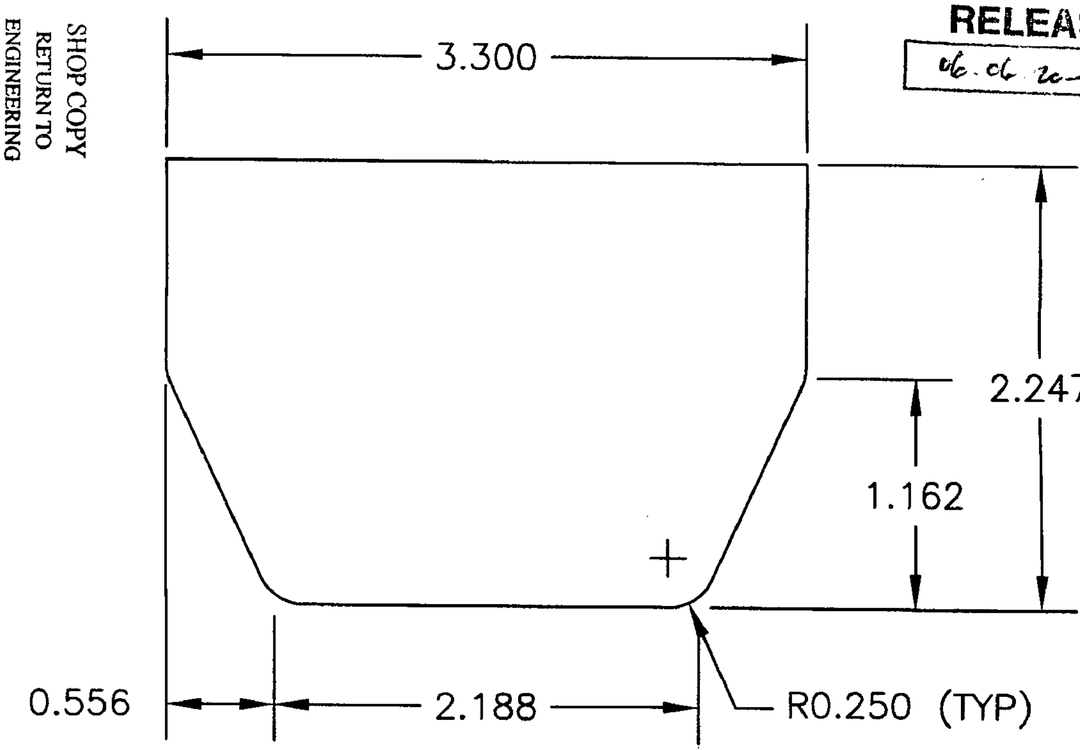
A	97.05.06	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

DART

END PLATE FOR D2244 EXTRUSION CUT AT 34°

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81968 MLS 12/03/14

RELEASED
06.06.20



D2673-34

NOTES:

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries